

Work Order ID 62834

Friday, October 08, 2010 12:50:06 PM

Page 1

Item ID: D3294-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/8/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *R* Date: 10-10-8Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

2024 .090

Memo

1-Cut as per Dwg D3294

Dwg Rev: *E* Prog Rev: *E*

*grain direction on a 45 deg as per dwg**

2-Deburr if necessary

 *B*10-10-13 *(7)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

 *B*10-10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

JM-03

0.00

Quality Control

A1272

7

10/10/15

130

0.00



Brake NC

Memo

1-Deburr if necessary
2-Bend as per Dwg D3294
(Ensure angle is correct)

0.00

Brake NC

SB 10/10/26

7

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/26

+7

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Start Date: 10/8/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
160  QC	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
170  Small Fab		0.00							
	Memo	0.00							
Small Fab	1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294								

BR 10-10-26

(7)

E 510/10/26 (7)

E 510/10/26 (7)

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Friday, October 08, 2010 12:50:06 PM



Page 4

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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		51010126		(+7)			
190 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M112588 Memo Start Time: 10:40 Oven Temperature: 320° Finish Time: 11:10	0.00 0.00				7		BL 10-10-27	
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10/10/27		7	0		

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 2/2

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28
sf (70) sf

10/10/28

NF
10-10-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, October 08, 2010* 12:50:10 PM

Page 1

Work Order ID: 62834

Parent Item: D3294-1

Parent Item Name: Bracket


Start Date: 10/8/2010

Required Date: 10/15/2010


Start Qty: 6.00

Required Qty: 6.00


Comments: IPP ☐ A ☐ 04.08.24 ☐ New issue ☐ KJ/JLM ☐
 IPP Rev:B Now On Waterjet 07-03-26 JLM
 IPP Rev:C 08-07-16 Redesign part DD verified by:EC
 IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080  2024-T3 .080 sheet		Purchased	No			100	sf	100.6000	1.8	11.36842	126	10-10-13	

Location	Loc Qty	Loc Code
MAT22	100.6	
104921	2	
105411	7	
112331	3	
113796	9.7	
114025	78.9	

D3294-5  Doubler		Manufactured	No			170	Each	24.0000	1				
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Location	Loc Qty	Loc Code
WA	24	
55331	24	

MS20470AD4-5  Rivet, Universal Head		Purchased	No			170	Each	797.0000	15	90			
---	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST309	732	
114761	732	
ST319	65	
111916	65	

⑦

114025
6
E 5/10/10/26

7
90
E 5/10/10/26

105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62834
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	✓		V PRO	
Ø0.141	+0.005/-0.001	.143	✗		V	
6.708	+/-0.010	6.706	✗		V	
1.118	+/-0.010	1.116	✗		V	
5.590	+/-0.010	5.588	✗		V	
1.118	+/-0.010	1.116	✗		V	
13.563	+/-0.010	13.563	✗		T H301	
1.043	+/-0.010	1.040	✗		V	
0.625	+/-0.010	.626	✗		V	
0.325	+/-0.010	.323	✗		V	
0.300	+/-0.010	.303	✗		V	
0.400	+/-0.010	.298	✗		V	
6.000	+/-0.010	6.000	✗		V	
1.000	+/-0.010	1.000	✓		V	
17.124	+/-0.010	17.130	✗		T	
16.13	+/-0.030	16.13	✗		T	
7.27	+/-0.030	7.273	✗		V	
11.97	+/-0.030	11.964	✗		V PRO 02	
8.37	+/-0.030	8.368	✗		V PRO 02	
20.05	+/-0.030	20.05	✗		T	
12.98	+/-0.030	12.98	✗		T	
14.59	+/-0.030	14.59	✗		T	
11.66	+/-0.030	11.664	✗		V PRO 02	
0.080	+/-0.010	.079	✗		V	

Measured by:	LB	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	10-10-13	Date:	10-10-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	[Signature]

W/O:		WORK ORDER CHANGES					
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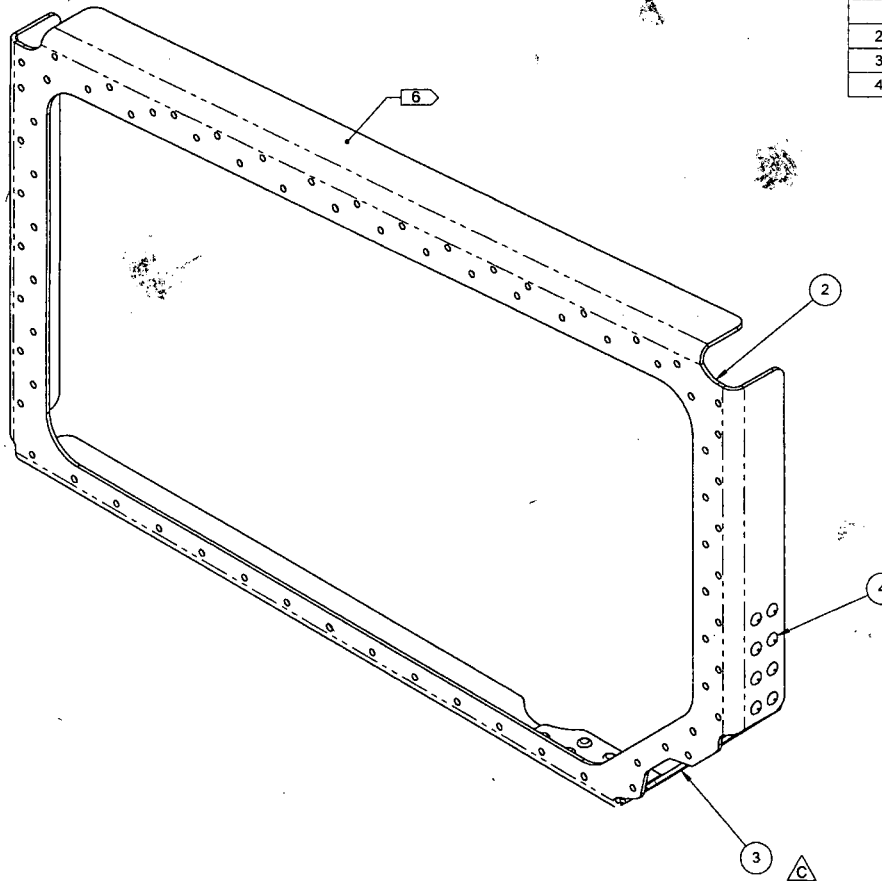
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY
RETURNED
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHIN OFFICE
WORK ORDER
NO. 62834
210-108

RELEASED
09/04/17

REV.	DESCRIPTION	BY	DATE
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

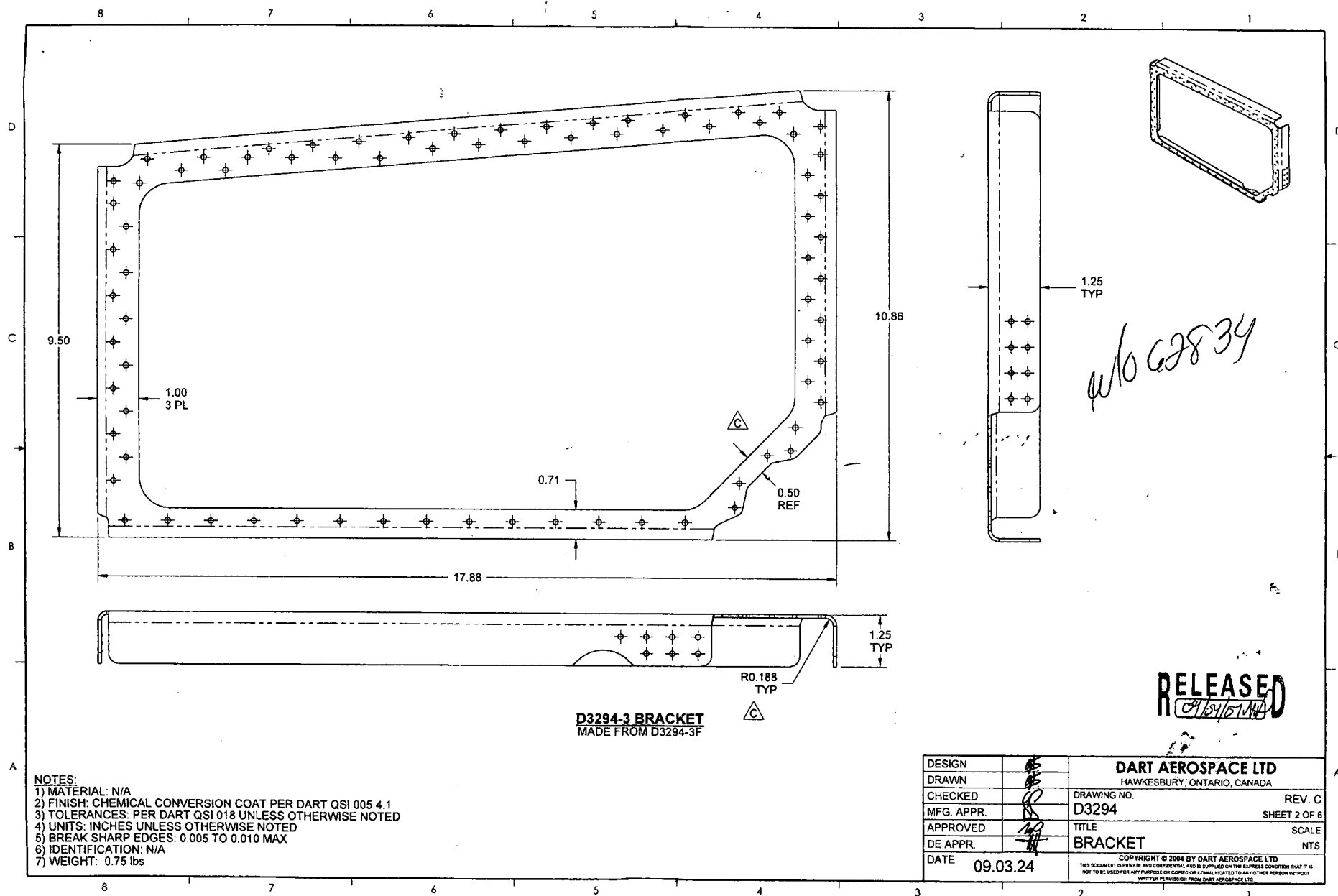
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NOTE: Date & initial all entries



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MFG. APPR.		D3294	SHEET 2 OF 6
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DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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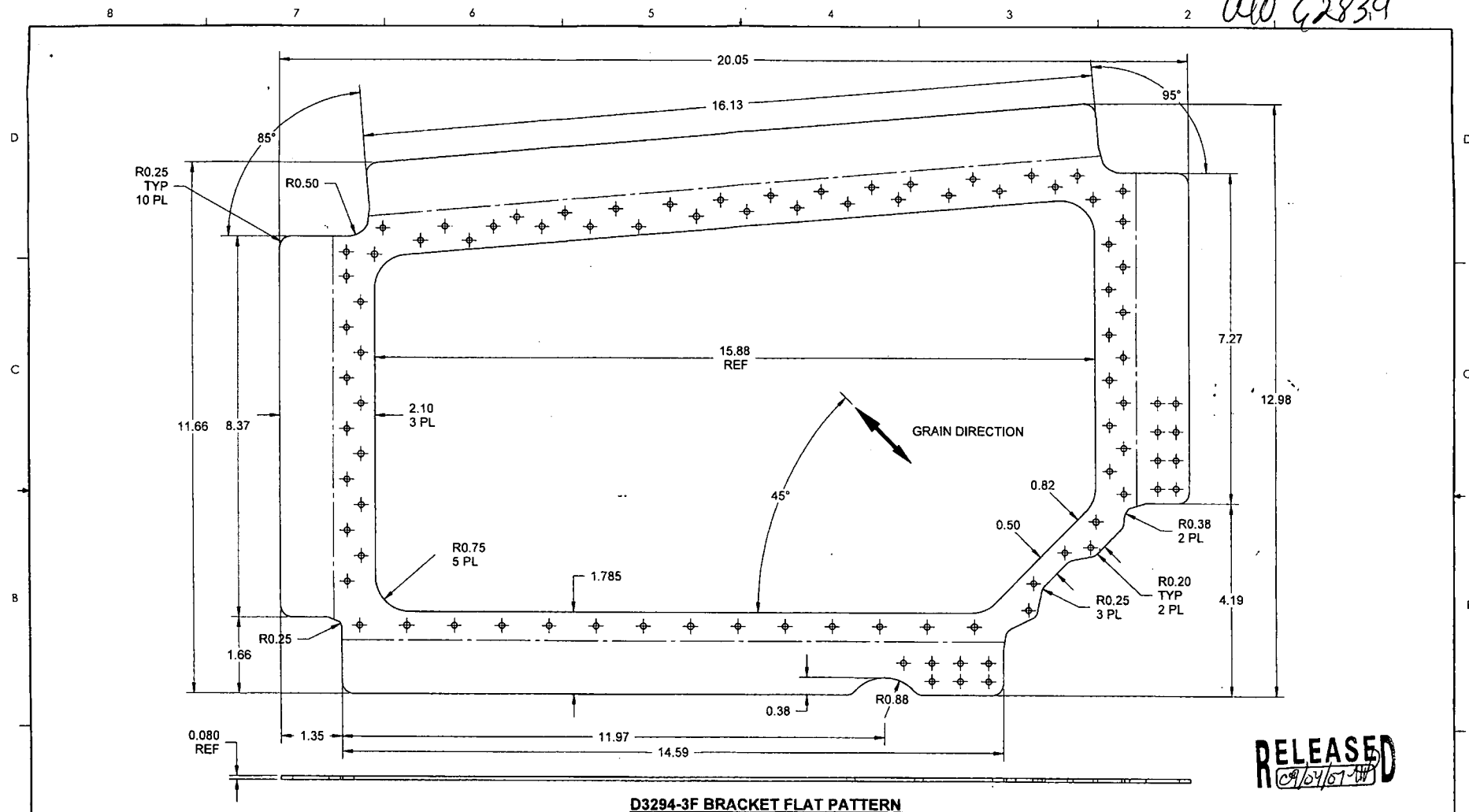
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




NOTE: Date & initial all entries

W0 G2834



RELEASED
09/04/07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

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MFG. APPR.		D3294	SHEET 3 OF 6
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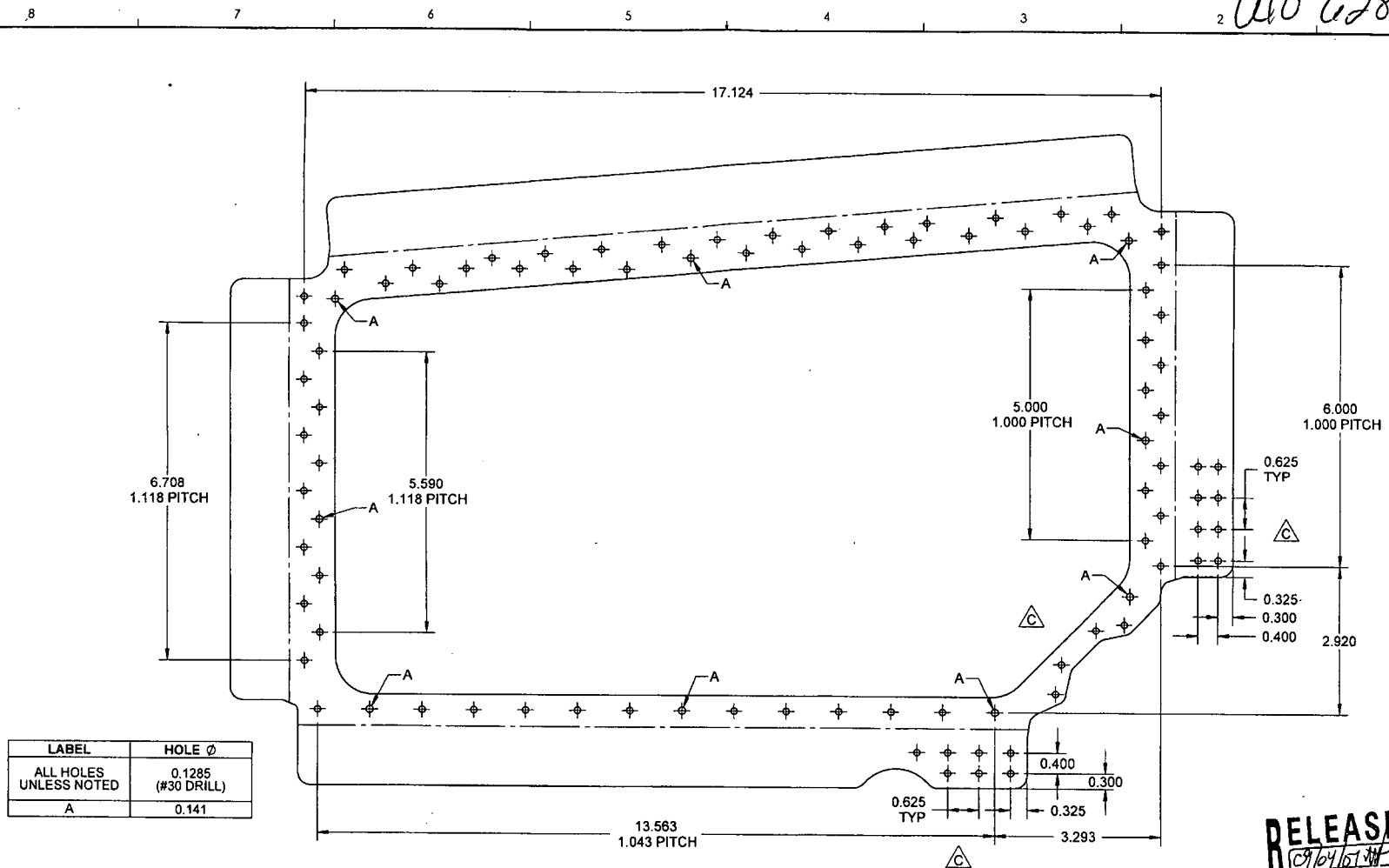
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NOTE: Date & initial all entries







2 u10 62834



LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL

RELEASED
09/03/24

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 4 OF 6	
DRAWN				
CHECKED		DRAWING NO. D3294	SCALE NTS	
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DE APPR.				
DATE	09.03.24			

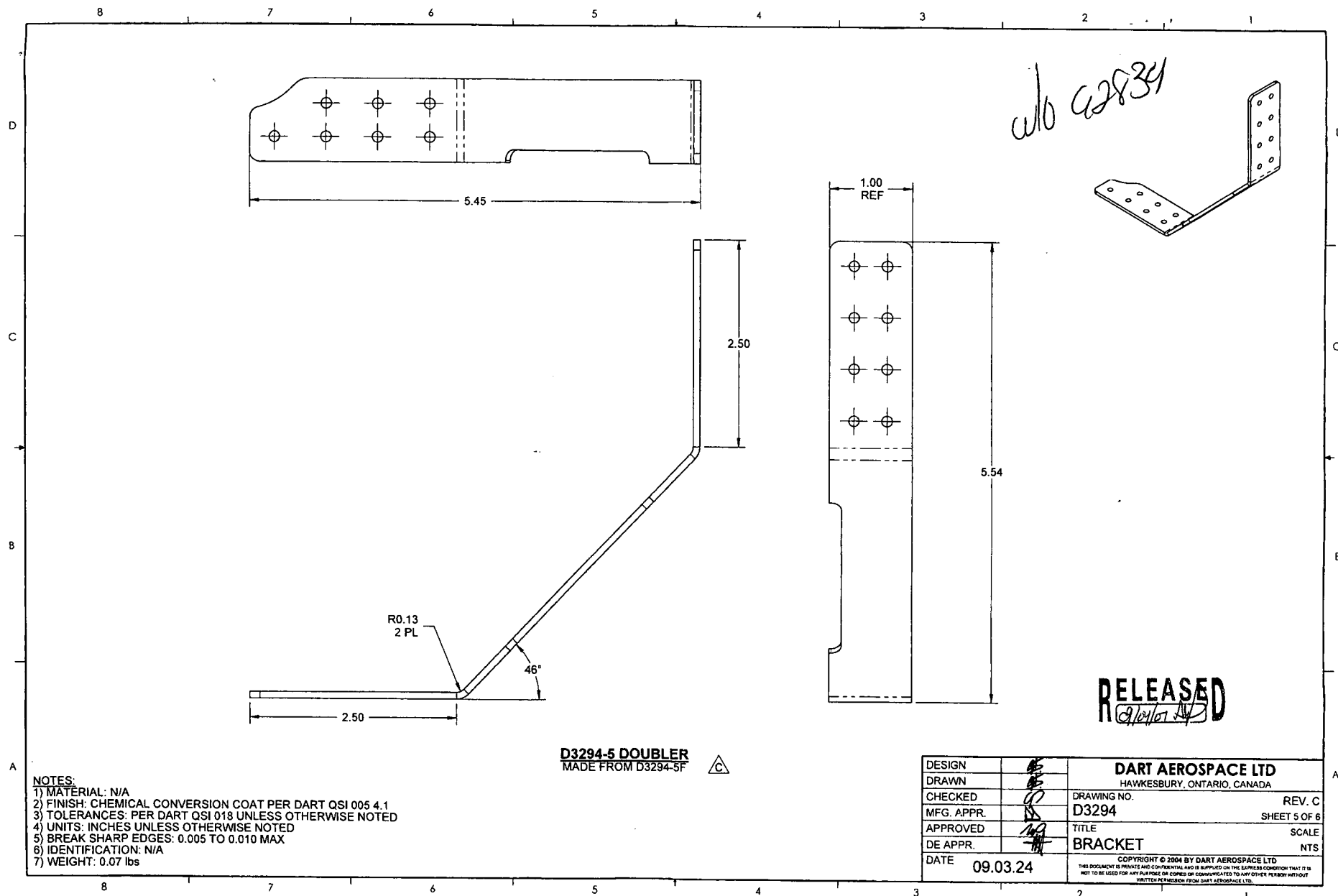
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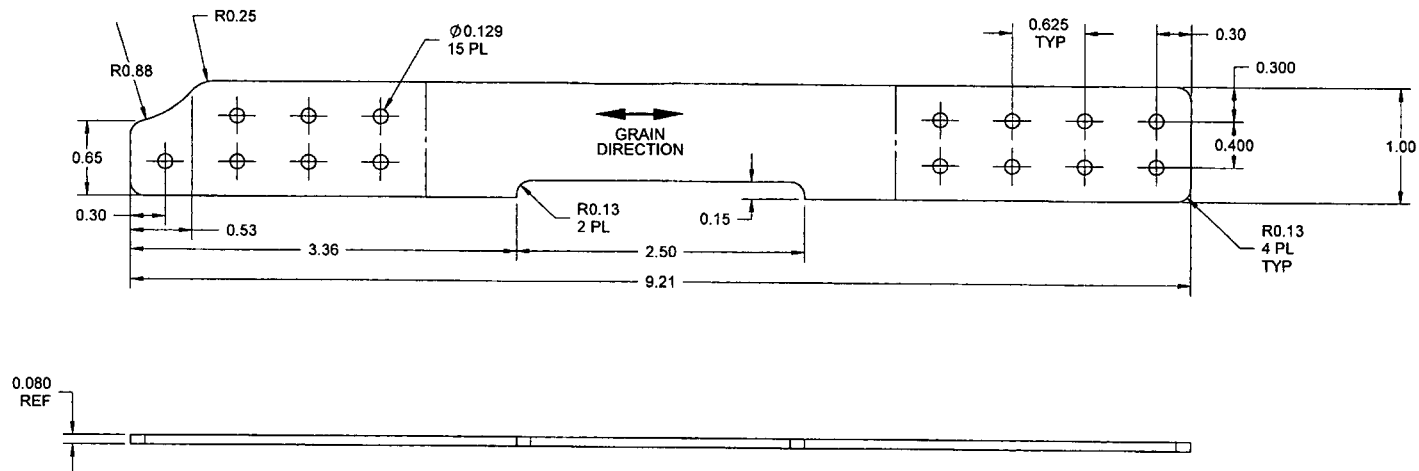
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NOTE: Date & initial all entries

Wb 62839









D3294-5F DOUBLER FLAT PATTERN



RELEASED
09/04/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 6 OF 6
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Dart Aerospace Ltd

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